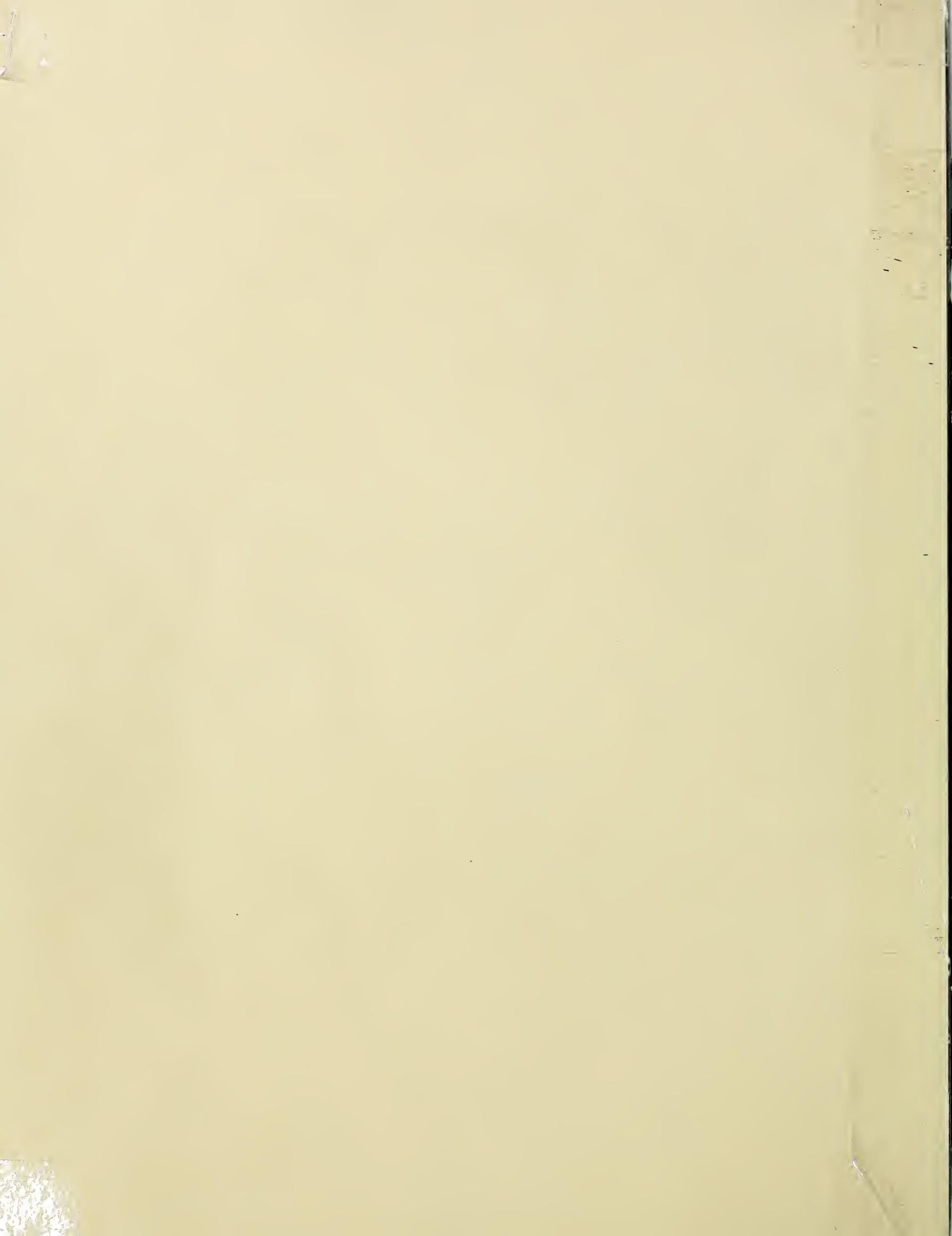


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United States
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Agriculture

Food Safety
and Inspection
Service

HACCP-1

March 1994

Generic HACCP* Model for Refrigerated Foods

*Hazard Analysis
and Critical Control
Point (HACCP)

Refrigerated Foods

Refrigerated Foods REFRIGERATED FOODS

REFRIGERATED FOODS Refrigerated Foods

REFRIGERATED FOODS

Refrigerated Foods

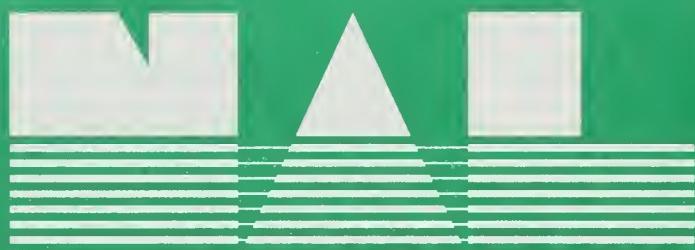
Refrigerated Foods REFRIGERATED FOODS

REFRIGERATED FOODS Refrigerated Foods

REFRIGERATED FOODS

Refrigerated Foods

**United States
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Agriculture**



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Introduction

HACCP Generic Model for Refrigerated Foods

Hazard Analysis and Critical Control Points (HACCP) is a system of process control. It is designed to prevent the occurrence of problems by ensuring that controls are applied at any point in a food production system where hazardous or critical situations could occur. Hazards could include microbiological, chemical, or physical adulteration of food products.

In late May 1993, U.S. Department of Agriculture (USDA) Secretary Mike Espy directed USDA's Food Safety and Inspection Service (FSIS) to provide him with a plan for implementing mandatory HACCP in the nation's meat and poultry establishments. The Secretary recognized that such a system, which has been under study by FSIS, was a necessary building block of the inspection system of the future.

In workshops held in 1991 and 1992, five generic HACCP models were developed and are being published for public information. The models should be useful for companies developing individualized plans.

The five generic HACCP models are:

- Refrigerated Foods
- Cooked Sausage
- Poultry Slaughter
- Fresh Ground Beef
- Swine Slaughter



The workshop for Refrigerated Foods was held in Baltimore, Maryland, from February 26-28, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 14 critical control points (CCP's) for refrigerated foods, including: preparation, cooking, chilling, assembling components into packages, flushing with gas atmosphere, package inspection, labeling and code dating, chilling, and storage. This is the generic HACCP model for Refrigerated Foods.

Information on the other four workshops follows:

The workshop for Poultry Slaughter was held in Atlanta, Georgia, from August 27-29, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for poultry slaughter, including: receiving, scalding, venting/opening/eviscerating, offline procedures, neck and giblet chilling, final wash, carcass chilling, packaging/labeling, and storage/distribution. This is the generic HACCP model for Poultry Slaughter.

The workshop for Fresh Ground Beef was held in Phoenix, Arizona, from December 3-5, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for fresh ground beef, including: sanitation, receiving, storage, assembly/pre-weigh/pre-grind (re-work), final grind, packaging/labeling, storage, and shipping. This is the generic HACCP model for Fresh Ground Beef.

The workshop for Pork Slaughter (Market Hogs) was held in Minneapolis, Minnesota, from March 31-April 2, 1992. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 10 critical control points (CCP's) for pork slaughter, including: receiving/holding, scalding, dehairing, trimming, neck breaker/head dropping/brisket opening, splitting, trim rail/final rail inspection for trimming, cooler, operational sanitation, and pre-op sanitation. This is the generic HACCP model for Pork Slaughter (Market Hogs).

The workshop for Cooked Sausage was held in Fort Worth, Texas, from May 21-23, 1991. Over 40 technical and subject matter experts from industry and government collaborated in the generic model development. Participants identified 9 critical control points (CCP's) for cooked sausage, including: receiving, meat preparation, non-meat ingredient compounding, pre-blend/formulation/staging (re-work), cooking/smoking, chilling/storage, peeling, packaging, and storage. This is the generic HACCP model for Cooked Sausage.

PRODUCT CATEGORY DESCRIPTION

PRODUCT CATEGORY : COOKED AND ASSEMBLED FOODS

WORKSHOP LOCATION : BALTIMORE, MD.

THE FOLLOWING QUESTIONS NEED TO BE ANSWERED WHEN DEVELOPING THE PRODUCT CATEGORY DESCRIPTION.

COMMON NAME? COOKED POULTRY AND BEEF WITH STARCH AND VEGETABLES IN SEASONED SAUCE WITH HEAT-TREATED GARNISH

HOW IS IT TO BE USED? READY TO EAT OR HEAT AND SERVE

TYPE OF PACKAGE? SEALED CONTAINER WITH MODIFIED ATMOSPHERE

LENGTH OF SHELF LIFE, AT WHAT TEMPERATURE? EXTENDED SHELF LIFE UNDER REFRIGERATION WITHIN THE LIMITS OF SAFETY

WHERE WILL IT BE SOLD? RETAIL UNDER REFRIGERATION

LABELING INSTRUCTIONS? IMPORTANT: MUST BE KEPT REFRIGERATED; USE BY DATE APPLICABLE TO FURTHER HANDLING REQUIREMENTS

IS SPECIAL DISTRIBUTION CONTROL NEEDED? MAINTAIN DISTRIBUTION TEMPERATURES IN ACCORDANCE WITH MANUFACTURERS INSTRUCTIONS

LIST PRODUCT CATEGORIES AND INGREDIENTS

PRODUCT CATEGORY : COOKED AND ASSEMBLED

WORKSHOP LOCATION : BALTIMORE, MD

| MEAT AND MEAT BYPRODUCTS | NONMEAT FOOD INGREDIENTS | BINDERS/EXTENDERS |
|---------------------------------------|---|---|
| RAW POULTRY | FRESH VEGETABLE FROZEN VEGETABLE CANNED VEGETABLE STARCH COMPONENT | MODIFIED FOOD STARCH |
| SPICES/FLAVORINGS BLACK PEPPER | RESTRICTED INGREDIENTS SODIUM PHOSPHATE | PRESERVATIVES/ ACIDIFIERS VINEGAR |
| OTHER | | |
| PAGE RS B3 | | 01/18/91 RS A12 |

| PROCESS FLOW DIAGRAM | |
|----------------------------------|--|
| PRODUCT CATEGORY | : COOKED AND ASSEMBLED |
| WORKSHOP LOCATION | : BALTIMORE, MD |
| MEAT | NON-MEAT |
| RECEIVING | RECEIVING |
| STORAGE | STORAGE |
| PREPARATION | PREPARATION |
| COOKING | CCP4-P CCP5-M CCP6-M |
| CHILLING | COOKING CHILLING |
| ASSEMBLE COMPONENTS INTO PACKAGE | |
| ASSEMBLE COMPONENTS INTO PACKAGE | CCP7-M CCP8-M |
| FLUSH WITH GAS ATMOSPHERE | |
| SEAL PACKAGE | |
| PACKAGE INSPECTION | |
| LABELING AND CODE DATING | CCP9-M, CCP10-P CCP11-M, CCP12-C |
| CHILLING | CCP13-M |
| STORAGE | CCP14-M |
| | REV: 04/15/92 STEERING COMMITTEE |

Note: The use of specifications, vendor certification, letters of guarantee and encouraging vendors to use HACCP is important in the development of HACCP plans. Based on the ingredient(s) and it's supplier or manufacturer, use of this concept may help in the control of microbial and/or chemical and/or physical hazards.

The use of this concept as a CCP for any or all of the hazards is very product and process specific

We recommend that all HACCP plans need to consider this and make decisions about its inclusion based on experience with the ingredient(s) and it's supplier/manufacturer along with sound scientific principles

INDUSTRY HACCP WORKSHOP

FINISHED PRODUCT/INGREDIENT HAZARD ANALYSIS/RISK ASSIGNMENT

PRODUCT CATEGORY : COOKED AND ASSEMBLED FOODS

WORKSHOP LOCATION: BALTIMORE, MD.

PRODUCT HAZARD : MICROBIOLOGICAL

*HAZARD CHARACTERISTIC (A) N/A for industry generic workshop HACCP model.

NOTE:

1. When doing Finished Product hazard analysis risk assignment, consider all ingredients and processes used in the establishment to produce the Finished Product.
 2. When doing hazard analysis and risk assignment on ingredients, consider only those processes taking place prior to product arriving at the receiving dock of the consuming establishment.

01/18/91

INDUSTRY HACCP WORKSHOP

FINISHED PRODUCT/INGREDIENT HAZARD ANALYSIS/RISK ASSIGNMENT

PRODUCT CATEGORY : COOKED AND ASSEMBLED FOODS

WORKSHOP LOCATION: BALTIMORE, MD.

PRODUCT HAZARD : CHEMICAL

*HAZARD CHARACTERISTIC (A) N/A for industry generic workshop HACCP model.
NOTE:

NOTE:

1. When doing Finished Product hazard analysis risk assignment, consider all ingredients and processes used in the establishment to produce the Finished Product.
 2. When doing hazard analysis and risk assignment on ingredients, consider only those processes taking place prior to product arriving at the receiving dock of the consuming establishment.

INDUSTRY HACCP WORKSHOP

FINISHED PRODUCT/INGREDIENT HAZARD ANALYSIS/RISK ASSIGNMENT

PRODUCT CATEGORY : COOKED AND ASSEMBLED FOODS

WORKSHOP LOCATION: BALTIMORE, MD.

PRODUCT HAZARD : PHYSICAL

*HAZARD CHARACTERISTIC (A) N/A for industry generic workshop HACCP model.

NOTE:

1. When doing Finished Product hazard analysis risk assignment, consider all ingredients and processes used in the establishment to produce the Finished Product.
 2. When doing hazard analysis and risk assignment on ingredients, consider only those processes taking place prior to product arriving at the receiving dock of the consuming establishment.

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED
WORKSHOP LOCATION: BALTIMORE, MD

INDUSTRY WORKSHOP HACCP MODEL

| PROCESS STEP | CCP / HAZARD NUMBER | CCP DESCRIPTION | CRITICAL LIMITS | ESTABLISHMENT MONITORING | CORRECTIVE/PREVENTIVE ACTION | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|---------------------|---------------------|----------------------------------|--|---|---|---|--|
| PREPARATION | | | | | | | |
| POULTRY/MEAT | CCP1-P | BONE FRAGMENTS, FOREIGN MATERIAL | DEFECT-SIZE AND NUMBER WILL BE SET BY PLANT. | EACH LOT WILL MEET SPECIFICATION BY PLANT ESTABLISHED TEST PROCEDURE. | PLACE PRODUCT INVOLVED ON HOLD; REWORK OR REJECT. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. |
| COOKING | | | | | | | |
| POULTRY/MEAT | CCP2-M | TIME, TEMPERATURE | TIME / TEMPERATURE SUFFICIENT FOR VEGETATIVE PATHOGEN KILL AS DETERMINED BY A PROCESSING AUTHORITY BUT NOT LESS THAN A MINIMUM USDA TEMPERATURE. | TIME/TEMPERATURE PHYSICAL MEASUREMENTS. | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED
 WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP / HAZARD NUMBER | CCP DESCRIPTION | CRITICAL LIMITS | ESTABLISHMENT MONITORING | CORRECTIVE/PREVENTIVE ACTION | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|------------------------------|---------------------|-----------------|--|--|---|---|--|
| CHILLING POULTRY/MEAT | CCP3-M | TIME | RAPIDLY AS POSSIBLE TO ASSURE PRODUCT SAFETY. | MEASURE TIME, PRODUCT AND/OR COOLING MEDIUM TO MEET CRITICAL LIMITS WITH APPROPRIATELY CALIBRATED AND ACCURATE DEVICES. | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |
| POULTRY/MEAT | CCP3-M | TEMPERATURE | LOW ENOUGH TO PRECLUDE THE GROWTH OF PATHOGENIC MICRO-ORGANISMS, FINISHED PRODUCT TO BE COOLED TO <40° F. WITHIN ESTABLISHED USDA GUIDELINES UNLESS EXEMPTED BY A QUALIFIED PROCESS AUTHORITY. | MEASURE TEMPERATURE OF PRODUCT AND/OR COOLING MEDIUM TO MEET CRITICAL LIMITS WITH APPROPRIATELY CALIBRATED AND ACCURATE DEVICES. | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED

WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP/ HAZARD NUMBER | CCP DESCRIPTION | Critical Limits | Establishment Monitoring | Corrective/Preventive Action | HACCP Records | HACCP System Verification |
|-------------------------|--------------------|-------------------|---|--|--|---|--|
| PREPARATION NON-MEAT | CCP4-P | FOREIGN MATERIAL | DEFECT-SIZE AND NUMBER WILL BE SET BY PLANT. | CONTINUOUS DETERMINATION THAT A PREVIOUSLY VERIFIED REMOVAL PROCESS IS IN OPERATION. | PLACE PRODUCT INVOLVED ON HOLD AND DETERMINE SIGNIFICANCE OF PROBLEM. CORRECT PROCESS. REWORK/REJECT PRODUCT ON HOLD. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. |
| COOKING NON-MEAT | CCPS-M | TIME, TEMPERATURE | TIME/ TEMPERATURE SUFFICIENT FOR VEGETATIVE PATHOGEN KILL AS DETERMINED BY A PROCESSING AUTHORITY. DEPENDS ON VEGETABLE. | TIME/TEMPERATURE PHYSICAL MEASUREMENT | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED
WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP / HAZARD NUMBER | CCP DESCRIPTION | CRITICAL LIMITS | ESTABLISHMENT MONITORING | CORRECTIVE/PREVENTIVE ACTION | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|----------------------|---------------------|-----------------|--|--|---|---|--|
| CHILLING NON-HEAT | CCP6-M | TIME | RAPIDLY AS POSSIBLE TO ASSURE PRODUCT SAFETY. | MEASURE TIME OF PRODUCT AND/OR COOLING MEDIUM TO MEET CRITICAL LIMITS WITH APPROPRIATELY CALIBRATED AND ACCURATE DEVICES. | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |
| NON-HEAT | CCP6-M | TEMPERATURE | LOW ENOUGH TO PRECLUDE THE GROWTH OF PATHOGENIC MICRO-ORGANISMS, FINISHED PRODUCT TO BE COOLED TO <40° F. WITHIN ESTABLISHED USDA GUIDELINES UNLESS EXEMPTED BY A QUALIFIED PROCESS AUTHORITY. | MEASURE TEMPERATURE OF PRODUCT AND/OR COOLING MEDIUM TO MEET CRITICAL LIMITS WITH APPROPRIATELY CALIBRATED AND ACCURATE DEVICES. | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED

WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP / HAZARD NUMBER | CCP DESCRIPTION | CRITICAL LIMITS | ESTABLISHMENT MONITORING | CORRECTIVE/PREVENTIVE ACTION | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|---|---------------------|------------------------------|---|--|---|---|---|
| ASSEMBLE POULTRY/MEAT AND NON-MEAT | CCP7-M | CROSS-CONTAMINATION | FALL WITHIN PRODUCT SAFETY REQUIREMENTS | PRE-OP AND OPERATIONAL SANITATION AND EMPLOYEE HYGIENE MONITORING AND ON-GOING VISUAL INSPECTION FOR COMPLIANCE WITH ESTABLISHED STANDARDS | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. |
| GAS FLUSH POULTRY/MEAT AND NON-MEAT | CCP8-M | PROPER HEAD SPACE, GAS BLEND | GAS VOLUME AND/OR COMPOSITION WITHIN ESTABLISHED REQUIREMENTS | APPROPRIATE BLEND AND/OR VOLUME MEASUREMENTS BASED ON ESTABLISHED SPECIFICATIONS | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED

WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP/ HAZARD NUMBER | CCP DESCRIPTION | Critical Limits | Establishment Monitoring | Corrective/Preventive Action | HACCP Records | HACCP SYSTEM Verification | |
|------------------------------|------------------------------|--------------------|--------------------|---|--|---|--|--|
| PACKAGE INSPECTION | POULTRY/MEAT AND NON-MEAT | CCP9-M | SEAL INTEGRITY | ADEQUATE TO CONTROL CONTENTS/ ATMOSPHERE | MONITOR SEAL INTEGRITY USING A STATISTICALLY SIGNIFICANT SAMPLING PLAN | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |
| POULTRY/MEAT AND NON-MEAT | | CCP10-P | METAL DETECTION | SUITABLE METAL DETECTOR PROPERLY CALIBRATED. | CONTINUOUS INSPECTION OF 100% OF PRODUCT | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED

WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP/HAZARD NUMBER | CCP DESCRIPTION | CRITICAL LIMITS | ESTABLISHMENT MONITORING | CORRECTIVE/PREVENTIVE ACTION | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|---------------------------|-------------------|--|---|--|---|---|--|
| LABELING AND CODE DATING | CCP11-M | CONSUMER CODE DATE, KEEP REFRIGERATED STATEMENT & MANUFACTURING CODE | LEGIBLE; ACCURATE WITHIN PREVIOUSLY DEFINED SAFETY LIMITS | PRE-OP REVIEW OF CODES. VISUAL/AUTOMATIC INSPECTION OF LABEL AND EQUIPMENT AT A FREQUENCY SUFFICIENT TO ASSURE LEGIBILITY AND ACCURACY OF LABELING | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. |
| POULTRY/MEAT AND NON-MEAT | CCP12-C | PROPER LABELING | LEGIBLE; ACCURATE FOR PRODUCT. | PRE-OP REVIEW OF PRODUCT/LABEL/ INGREDIENT CORRELATION VISUAL/AUTOMATIC INSPECTION OF LABEL AND EQUIPMENT AT A FREQUENCY SUFFICIENT TO ASSURE LEGIBILITY AND ACCURACY OF LABELING | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED

WORKSHOP LOCATION: BALTIMORE, MD

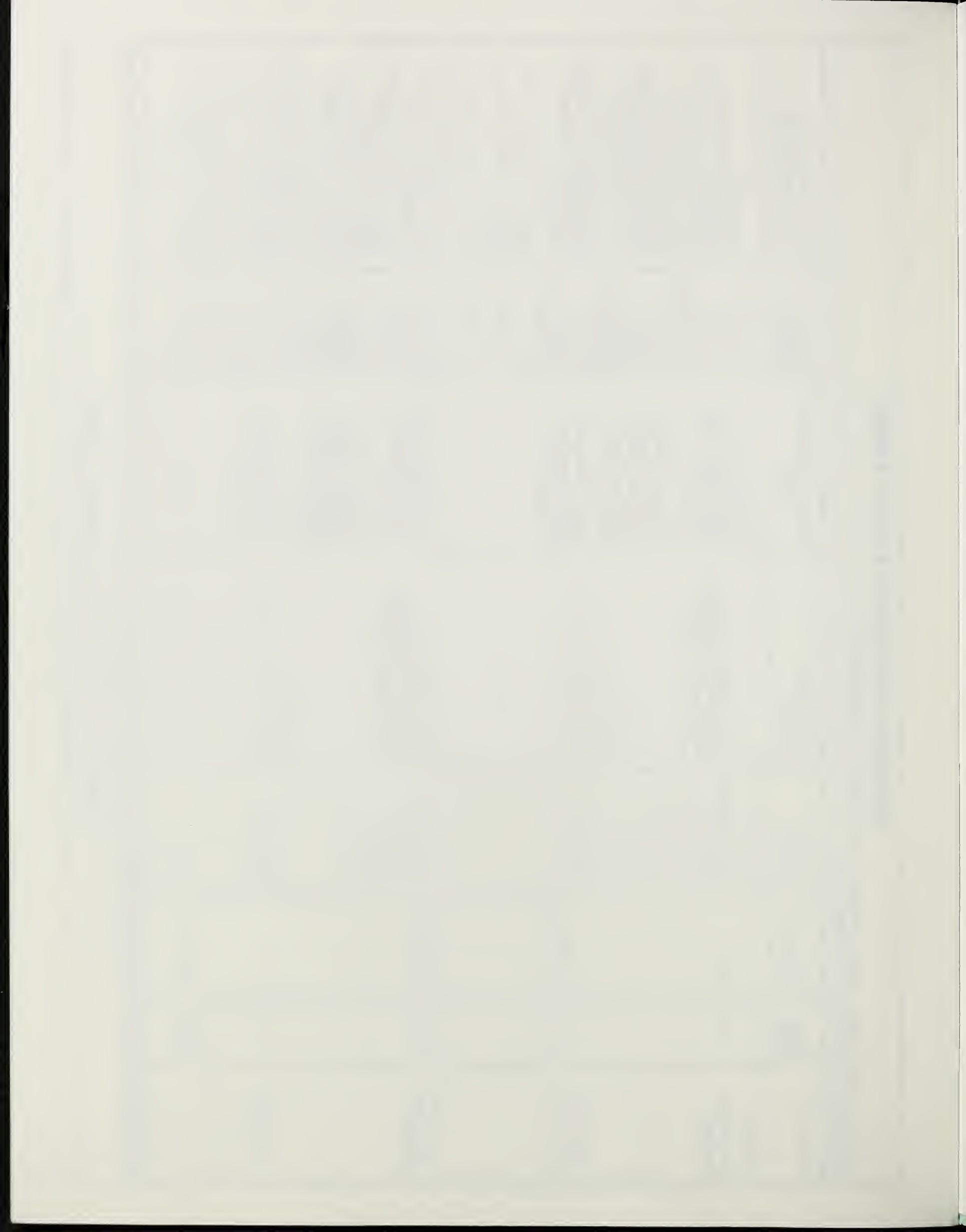
| PROCESS STEP | CCP / HAZARD NUMBER | CCP DESCRIPTION | Critical Limits | Establishment Monitoring | Corrective/Preventive Action | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|--------------|---------------------------|---------------------|--|--|---|---|--|
| CHILLING | POULTRY/MEAT AND NON-MEAT | CCP13-M TIME | RAPIDLY AS POSSIBLE TO ASSURE SAFETY. | USING A PROVEN RELIABLE METHOD, MONITOR TIME VERSUS TEMPERATURE OF ENVIRONMENTAL AND/OR INTERNAL TEMPERATURE | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |
| | POULTRY/MEAT AND NON-MEAT | CCP13-M TEMPERATURE | LOW ENOUGH TO PRECLUDE THE GROWTH OF PATHOGENIC MICRO-ORGANISMS, FINISHED PRODUCT TO BE COOLED TO <40° F. WITHIN ESTABLISHED USDA GUIDELINES UNLESS EXEMPTED BY A QUALIFIED PROCESS AUTHORITY. | USING A PROVEN RELIABLE METHOD, MONITOR TIME VERSUS TEMPERATURE OF BOTH INTERNAL PRODUCT TEMPERATURE AND ENVIRONMENT | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |

INDUSTRY WORKSHOP HACCP MODEL

PRODUCT CATEGORY: REFRIGERATED FOODS-COOKED AND ASSEMBLED

WORKSHOP LOCATION: BALTIMORE, MD

| PROCESS STEP | CCP / HAZARD NUMBER | CCP DESCRIPTION | CRITICAL LIMITS | ESTABLISHMENT MONITORING | CORRECTIVE/PREVENTIVE ACTION | HACCP RECORDS | HACCP SYSTEM VERIFICATION |
|--|---------------------|-----------------|--|--|---|---|--|
| STORAGE POULTRY AND NON-MEAT | CCP14-M | TIME | NOT TO EXCEED SHELF LIFE. | USING A PROVEN RELIABLE METHOD, MONITOR TIME VERSUS TEMPERATURE OF ENVIRONMENT AND/OR INTERNAL PRODUCT | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |
| POULTRY AND NON-MEAT | CCP14-M | TEMPERATURE | LOW ENOUGH TO PRECLUDE THE GROWTH OF PATHOGENIC MICRO-ORGANISMS. | USING A PROVEN RELIABLE METHOD, MONITOR TIME VERSUS TEMPERATURE OF ENVIRONMENT AND/OR INTERNAL PRODUCT | PLACE PRODUCT INVOLVED ON HOLD AND EVALUATE SIGNIFICANCE OF THE DEVIATION. DISPOSITION BASED ON PREVIOUSLY APPROVED GUIDELINES FROM QUALITY ASSURANCE OR PROCESS AUTHORITY. EVALUATE CAUSE OF DEVIATION AND TAKE ACTION TO PREVENT RECURRENCES. | HARD COPY RECORD ON APPROPRIATE ESTABLISHMENT FORMS, COMPLETED BY APPROPRIATE PERSON, RECORDED AT CCP SITE ON A REAL TIME BASIS. RECORDS TO BE MAINTAINED FOR APPROPRIATE TIME PERIOD. | PERIODIC OBSERVATION AND/OR MEASUREMENT. AUDIT OF RELEVANT RECORDS, CONSUMER CONTACTS AND/OR PRODUCTS TO DETERMINE IF MONITORING IS SUFFICIENT AND CRITICAL LIMITS ARE ADEQUATE FOR SAFETY. PERFORM ONGOING REVIEW OF HACCP PLAN IN RESPONSE TO DEVIATIONS AND/OR SYSTEM AND PRODUCT MODIFICATIONS. DOCUMENT CALIBRATION OF TEST EQUIPMENT AT INTERVALS SUFFICIENT TO MEET CRITICAL LIMITS. |







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